

SPH11-1

JUNE 1

Item ID: D350-591-312
Revision ID:
Item Name: Heli-Access-Step, Long RH

Accept

N9000040100

Setup Start *NS1*
Stop *NS2*

Start Date: 5/07/13 Start Qty: 10.00
Required Date: 5/31/13 Req'd Qty: 10.00
Reference:

10
10

Cust Item ID:
Customer:

Approvals: Process Plan: MCS Date: 13-05-07 Tooling:
QC: Date: SPC (Y/N):

Run Start *NR1*
Stop *NR2*

Item ID Part # Plan Code Qty Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr Revision Nbr
D3272 Rev B

100 0.00
100 DOCUMENT CONTROL
DC 0.00
Document Control Memo
Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

(102) 06 13/5/27

110 0.00
110 Large Fab
Large Fab 0.00
Large Fab Memo
1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod 125127
123928
3-Grind End Plate flush

10 d

13.05.13
13.05.14

unlabeled

Work Order ID 101278

Mar 17-13 11:37:36 AM

101278

Item ID: D350-591-312

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long RH

Start Date: 5/07/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

(15) 13-05-14

DAS
09
2-89

130 QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

(15) 13-05-14

DAS
09
2-89

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10 ϕ Ak 13-05-15

Work Order ID: 101278

Rev'd 11/17/36/13/

101278

Item ID: D350-591-312

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long RH

Start Date: 5/07/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

10

φ

DAS
19
13.05.15

180

Large Fab

0.00

180

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod 125127

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10

φ

12

13.05.15

Work Order ID 101278

May-07-13 11:36 AM

101278

Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Aium

0.00

220

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

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0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

10 x 1/2" M / 13/05/20
RH

10 x 1/2" BR 13-5-22

1

W125620

230

230

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 125314

Memo

0.00

240

240

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

13 63

Work Order ID 101278

11/13/13 11:31:26 AM

101278

Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

10

10

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

M.L. 13/05/22 10x

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

DAS
06
9-83

13/5/27 10x

P10 →

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: AS1

DAS
06
9-83

12 13/6/13

DQA: Antz Date: 13/06/07

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: OK Date: 13/Work Order update only ☐

Work Order: <u>101278</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D350-591-312</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-2706</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input checked="" type="checkbox"/>	Rec/Store/Packaging <input checked="" type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--	--

Work Order ID 101278

10/07/13 11:33:36 AM

101278

Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step. Long RH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

10

10

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLS 13-06-01

MF
13-6-4

Work Order ID: 101278

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

101278

D350-591-312

Start Date: 5/07/13

Start Qty: 10.00

Required Date: 5/31/13

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No				Each	0.0000	1	10			
D3272-1													
Step													
D3067-1		Manufactured	No			110	Each	161.0000	1	10			
D3067-1													
End Plate													

B101153



**

x10

13.05.08

**

13.05.09

Location

Loc Qty

Loc Code

WA

95515

78

98655

5

98655

73

WA003

67582

83

68214

2

78608

1

79607

4

83855

1

90178

1

90486

3

95170

64

95930

6

10

Work Order ID: 101278

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

101278

D350-591-312

Start Date: 5/07/13

Required Date: 5/31/13

Start Qty: 10.00

Required Qty: 10.00

D3219-1

Manufactured No

110

Each

92.0000

2

20

D3219-1

Plate

**

13.05.09

Location

Loc Qty

Loc Code

WA003

92

73410

12

77674

6

89967

2

96264

12

D3066-1

Manufactured No

180

Each

61.0000

2

20

D3066-1

Spacer

**

13.05.15

Location

Loc Qty

Loc Code

WA003

61

95963

4

99840

57

180

Each

1,062.000

16

MS20600-AD4W4

Purchased

No

MS20600-AD4W4

Rivets

**

20
160

B 99840 →

160x

13.05.15

Location

Loc Qty

Loc Code

ST311

1062

123900

350

125406

712

180

Each

17.0000

1

10

D3065-041

Manufactured No

D3065-041

Step Leg Assembly Hi

**

13.05.15

Location

Loc Qty

Loc Code

WA003

17

79336

1

97928

16

10

May-07-13 11:37:39 AM

Shop Packet Print

Page 2

Shop Packet Print

Shop Packet Print

Work Order ID: 101278

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step. Long RH

101278

D350-591-312

Start Date: 5/07/13

Required Date: 5/31/13

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180

Each

161.0000

1

10

D3067-1

End Plate

**

13.05.21

Location

Loc Qty

Loc Code

WA

78

95515

5

98655

73

WAB

85

67542

68214

1

78608

4

79607

1

83855

1

90178

1

90486

3

95170

64

95930

6

250

Each

405.0000

2

20

**

AN3-35A

AN3-35A

Bolt

Purchased

No

Location

Loc Qty

Loc Code

FG

10

122800

10

ST352

395

125211

395

125211

M.A.D. 13/05/23

May-07-13 11:37:39 AM

Shop Packet Print

Page 3

Work Order ID: 101278
Parent Item: D350-591-312
Parent Item Name: Heli-Access-Step, Long RH

101278
D350-591-312

Start Date: 5/07/13

Required Date: 5/31/13

Start Qty: 10.00

Required Qty: 10.00

D3235-1

Manufactured No

250 Each

251.0000

**

D3235-1

Mounting Lug

Location

Loc Qty

Loc Code

ST470

251

90002

2

02286

96415

09256

05406

120

250

Each

64.0000

**

D3278-041

Manufactured No

D3278-041

Support Assembly

Location

Loc Qty

Loc Code

ST470

64

90706

1

97909

23

99297

40

250

Each

0.0000

**

AN960JD416

NAS1149D0463J

Purchased

No

AN960JD416

Washer

AN960JD516

NAS1149D0563J

Purchased

No

AN960JD516

Washer

Location

Loc Qty

Loc Code

ST504

2

1069059

2

123248

13/05/23

Work Order ID: 101278

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step. Long RH

101278

D350-591-312

Start Date: 5/07/13

Required Date: 5/31/13

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

127.0000

**

AN5-36A

Bolt

sl

Location

Loc Qty

Loc Code

ST338

1

123525

1

ST517

126

125388

126

Each

244.0000

**

D2618

D2618

Bushing

sl

Manufactured

No

Location

Loc Qty

Loc Code

ST013

244

89275

1

97780

124

99529

119

250

Each

420.0000

**

D2230-3

D2230-3

Lug

sl

Manufactured

No

Location

Loc Qty

Loc Code

FG

4

89045

4

ST469

416

89782

19

90514

1

94957

4

96117

373

97815

4

97903

8

98912

B101450

M.D.

13/05/23

Work Order ID: 101278

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step. Long RH

101278

D350-591-312

Start Date: 5/07/13

Required Date: 5/31/13

D2856-400

Manufactured No

250

Start Qty: 10.00

Required Qty: 10.00

266.9839

**

D2856-400-720

Abrasion Strip

694
2x (10x)

92058 4x M.I.D.
96375 16x M.I.D.
773

Location

Loc Qty

Loc Code

ST408

153.45

99378

153.45

ST410

38.5

95159

38.5

ST115

63735

0.6696

68076

0.3149

71164

8.46

81875

6.398

86905

0.9569

89352

24.6745

90764

33.56

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased

No

250

Each

4,195.000

**

MS21042L3

Nut

3*
sl

13/05/22
8

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

3906

123900

974

124291

2932

124291

M.I.D.

May-07-13 11:37:40 AM

Shop Packet Print

Page 6

Work Order ID: 101278

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step. Long RH

101278

D350-591-312

Start Date: 5/07/13

Required Date: 5/31/13

AN4-13A

Purchased

No

250

Each

863.0000

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Bolt

**

8 80

sl

Location

Loc Qty

Loc Code

FG

20

122808

20

Return 2012

8

122416

8

125388

812

ST514

23

122993

13

123900

10

125388

M.D.

MS21042L5

Purchased

No

250

Each

149.0000

MS21042L5

Nut

**

2 20

sl

Location

Loc Qty

Loc Code

ST506

149

123900

149

MS21042L4

Purchased

No

250

Each

485.0000

MS21042L4

Nut

**

8 80

sl

Location

Loc Qty

Loc Code

FP001

50

122452

38

8182

12

ST518

435

124231

435

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

AN960JD10

Washer

**

4 40

124392

M.D.

May-07-13 11:37:40 AM

Shop Packet Print

13/05/22 Page 7

DART**RELEASED**07 06 04 *H*

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005.4.3
BLACK ANTI-SKID PAINT PER DART QSI 005.4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

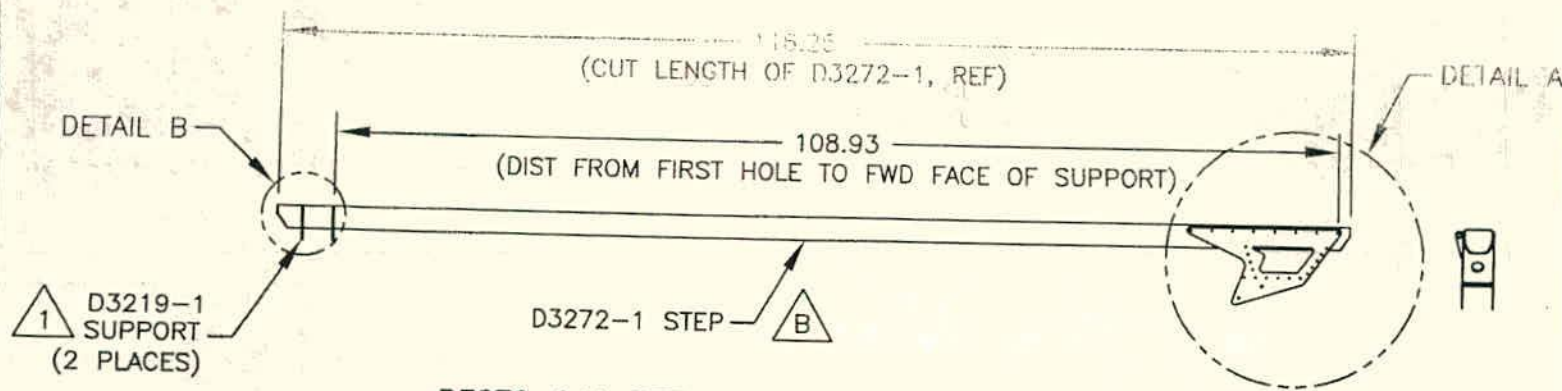
NO. 101228M15
13-05-07
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
101228M15
13-05-07

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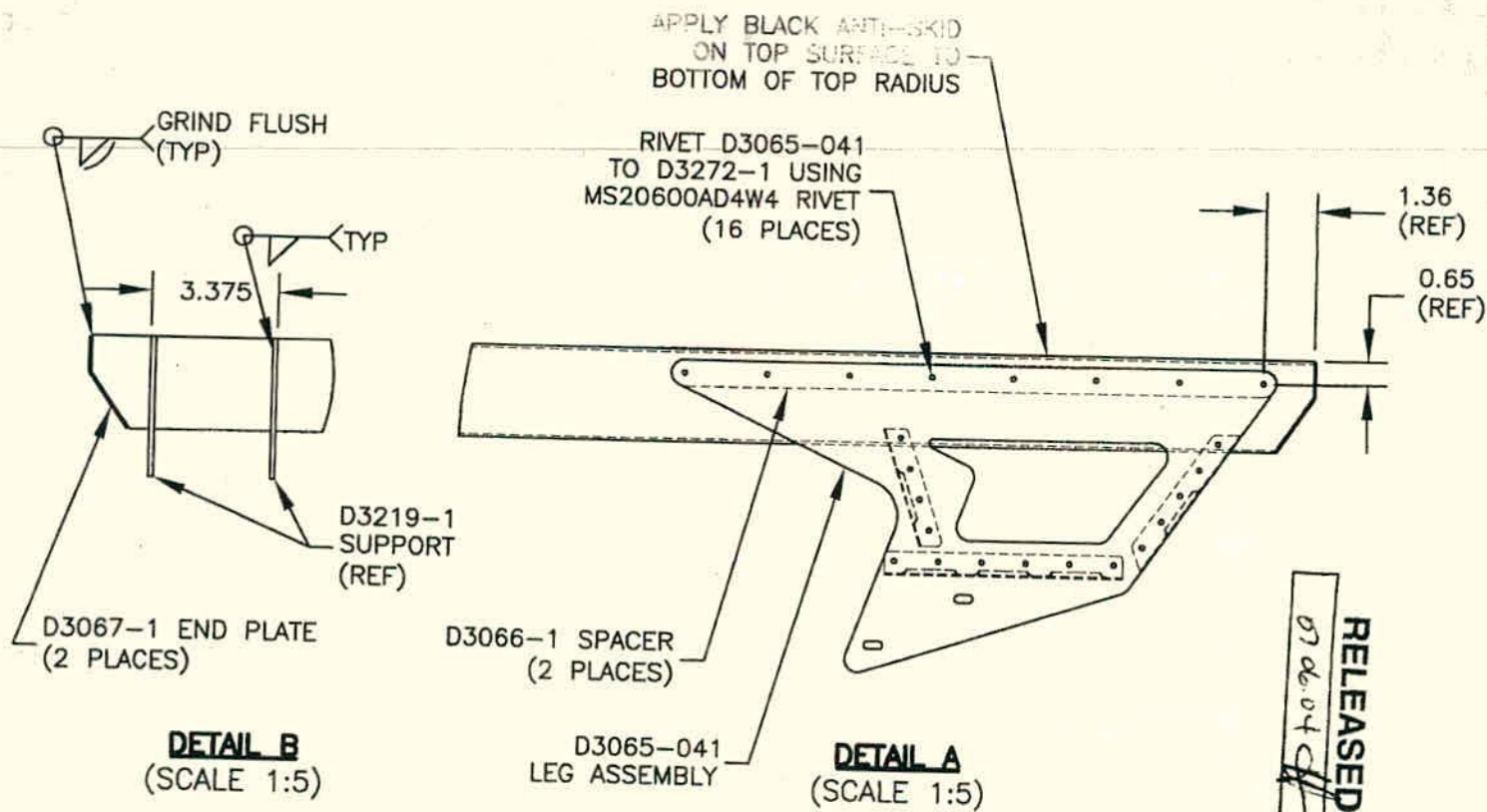
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10127e



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3	SCALE 1:20

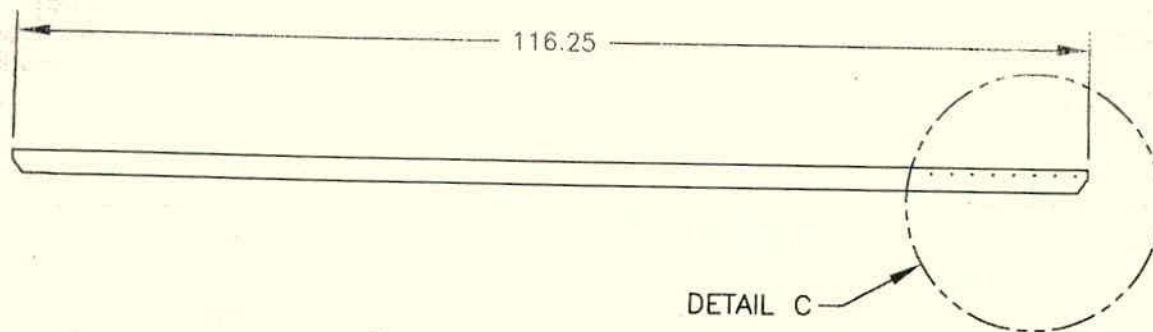
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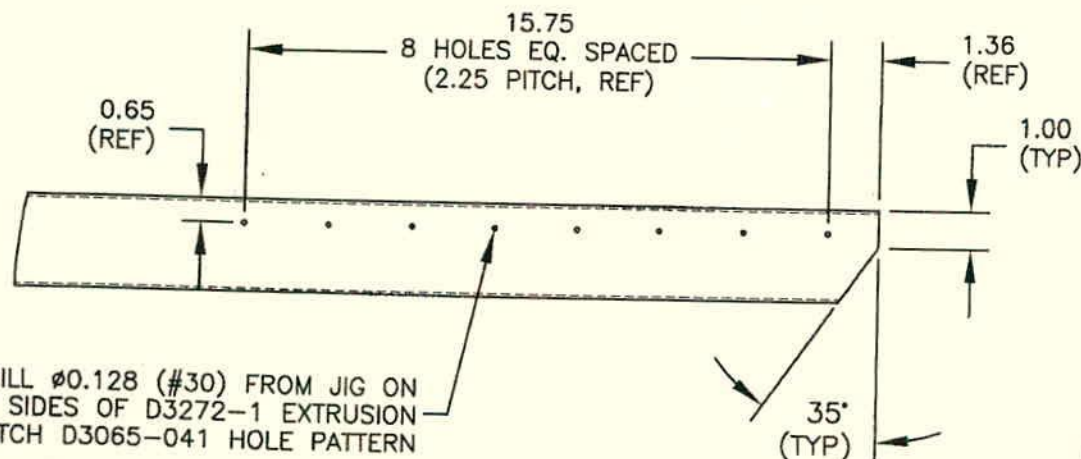


101270

DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	REV. B
DATE	07.05.18	DRAWING NO.	D3272
		TITLE	STEP ASSEMBLY, HI LONG
		SCALE	1:20



D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-7	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

101278

JUNE 1

Item ID: D350-591-312

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step, Long RH

Start Date: 5/07/13 Start Qty: 10.00

10

Required Date: 5/31/13 Req'd Qty: 10.00

10

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-05-07 Tooling:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

100

DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

MLS 13-05-23
10

110

110

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 125127

123928

3-Grind End Plate flush

10 d

13-05-13
13-05-14